

Spht-1
Work Order ID 157058-1

Friday, February 10, 2017 1:17:28 PM

157058

Page 1

Item ID: D2807-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Prop Assembly
Start Date: 2/10/2017 Start Qty: 24.00 *24* Cust Item ID:
Required Date: 2/24/2017 Req'd Qty: 24.00 *24* Customer:
Reference:

Approvals: Process Plan: mf Date: 17-2-10 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2807	Rev E								

100 PURCHASING 0.00
100
Purchasing Memo 0.00
Purchasing Issue P/O: 35290 Order as per Dwg D2807Possible
supplier: Lift Support Technologies, Saskatoon, Canada P/N 6/15-164/50-115N
Material release note is required

24 FEB 13 2017 13 2.50 DAS

110 Receive & Inspect for Damage & Mat'l Certs 0.00
110
Packaging Memo 0.08
Packaging Ensure Material Release Note is attached

24x 80 17-02-17

120 QC6- Inspect dimensions to drawing 0.00
120
QC Memo 0.00
Quality Control

24 38 2.50 DAS
FEB 23 2017

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150	Identify as per dwg & Stock Location: <u>Stall</u>	0.00	
150			
Packaging	Memo	0.04	
Packaging			

12

9-6-16

FEB 23 2017

Work Order ID 157058

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Item ID: D2807-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Prop Assembly
Start Date: 2/10/2017 Start Qty: 24.00 ***24*** Cust Item ID:
Required Date: 2/24/2017 Req'd Qty: 24.00 ***24*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00				DAS 21 9-89			
160									
QC	Memo	0.40							
Quality Control									

FEB 24 2017

DAS
21
9-89

FEB 24 2017

Picklist Print

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Work Order ID: 157058

157058

Parent Item: D2807-041

D2807-041

Parent Item Name: Prop Assembly

Start Date: 2/10/2017

Required Date: 2/24/2017

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP: D 07.11.12 ecn1019, replaces D2807 ECverified by DD
IPP Rev:E 08-02-12 ECN 1111 DD verified by: ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

6/15-164/50-115N

Purchased

No

130

Each

0.0000

1

24

6/15-164/50-115N

**

Gas Spring

D3671-1

Manufactured

No

110

Each

24.0000

1

24

D3671-1

**

Placard

Location

Loc Qty

Loc Code

GA

24

156055

14

150728

10

9/7/2017

12

24 x 2017-02-17

17/02/23

DAS
36
9-89

SPECIFICATION CONTROL DRAWING

(ALTERNATE ONLY)
CRIMP 0.015-0.025 DEEP
WITH $\varnothing 0.375$ TOOL AT
2000psi (REF), TYP TWO
SIDES PER LUG

0.24 TO CRIMP
(TYP)

D2807-5
OR
(ALTERNATE ONLY) D2807-1

AFFIX D3671-1 PLACARD
ENSURE PLACARD DOES NOT
CONCEAL ANY TEXT OR MARKINGS
ON THE GAS SPRING

(ALTERNATE ONLY) D2807-3
BOTH ENDS

ARROW POINTS OUTBOARD
ARROW POINTS INBOARD

4.88
COMPRESSED

6.46
EXTENDED

D2807-041 GAS SPRING

D2807-041 GAS SPRING ASSEMBLY PARTS LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D2807-041	GAS SPRING ASSEMBLY
1	D2807-5	GAS SPRING
1	D3671-1	PLACARD

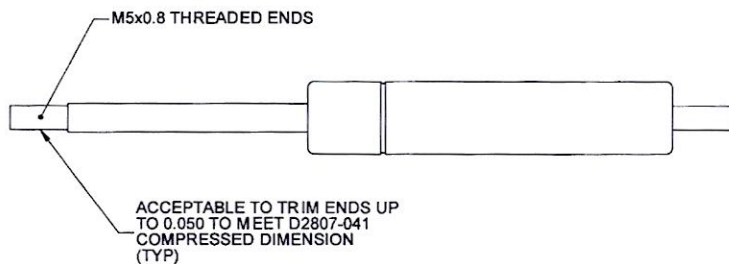
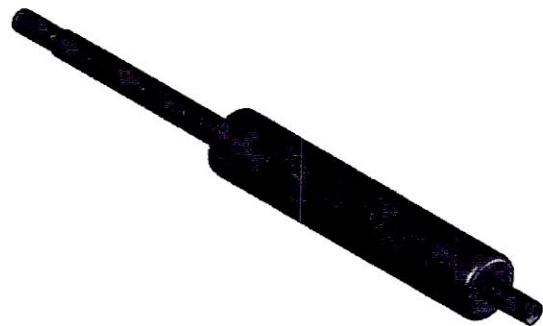
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) ALTERNATE PART: D2807-5 CAN BE MADE FROM ASSEMBLING D2807-1 (1) AND D2807-3 (2)
(WEIGHT: 0.176 LBS)

E

RELEASED

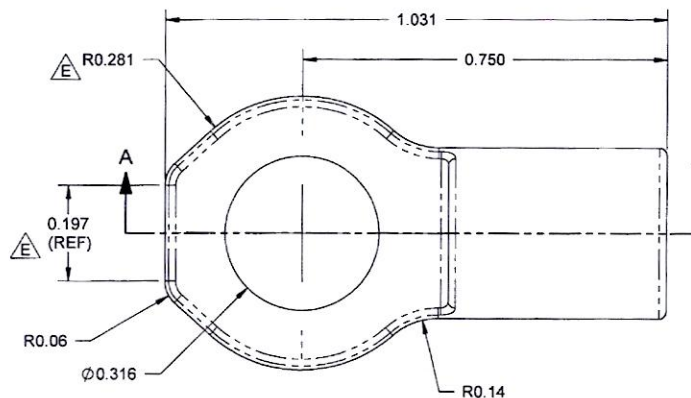
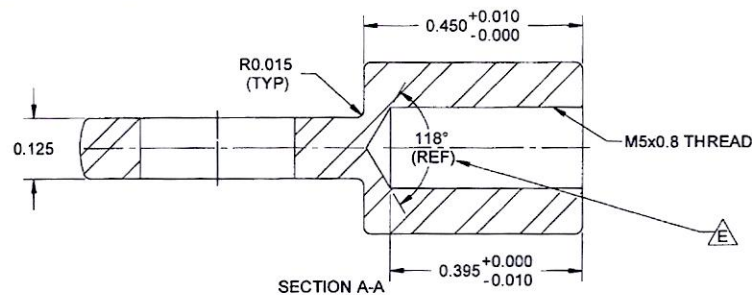
E	ADD D2807-5 GAS SPRING; D2807-1/-3 ASSEMBLY IS AN ALTERNATE TO D2807-5 GAS SPRING; UPDATE DIMENSIONS ON D2807-3	PH	07.12.28
D	ADDED D3671-1 PLACARD ADDED -041 ASSEMBLY UPDATED DWG	DC	07.09.27
C	CHANGE SPRING TO SS, ADD -3 LUG	CP	05.05.25
B	ADD FINISH	CP	05.03.16
A	NEW ISSUE	DS	00.11.03
REV.	DESCRIPTION	BY	DATE
DESIGN	AT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AT		
CHECKED	JE	DRAWING NO.	REV. E
MFG. APPR.	WPD	D2807	SHEET 1 OF 3
APPROVED	WPD	TITLE	SCALE
DE APPR.	WPD	GAS SPRING	NTS
DATE	07.12.28	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D2807-1 GAS SPRING
SCALE 1:1

D2807-1 GAS SPRING NOTES:

- 1) POSSIBLE SUPPLIER: ARVINMERITOR MOTION CONTROL SYSTEMS, LEICESTER, UK
(P/N SXF6S6050080S6L-115N)
(REF: 80MM LONG CYLINDER, 50MM STROKE, 115N LOAD)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.144 LBS
- 8) SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 LB (115 N) MIN TO 45 LB (200 N) MAX
M5x0.8 THREADS



D2807-3 LUG

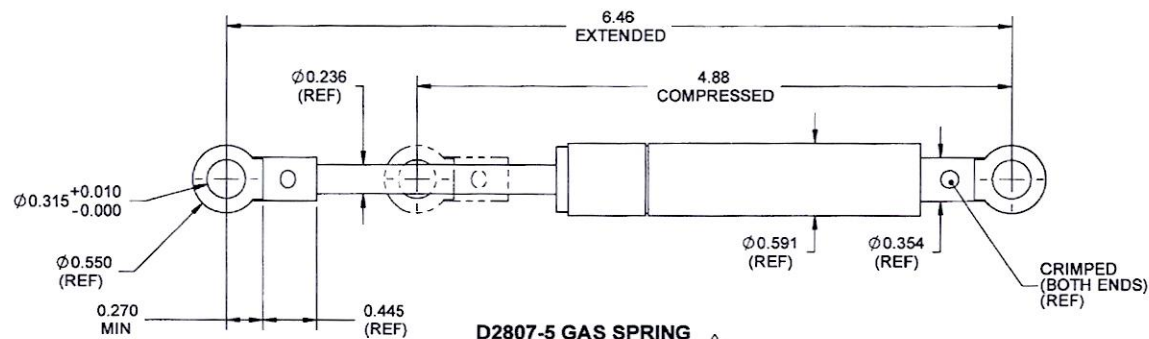
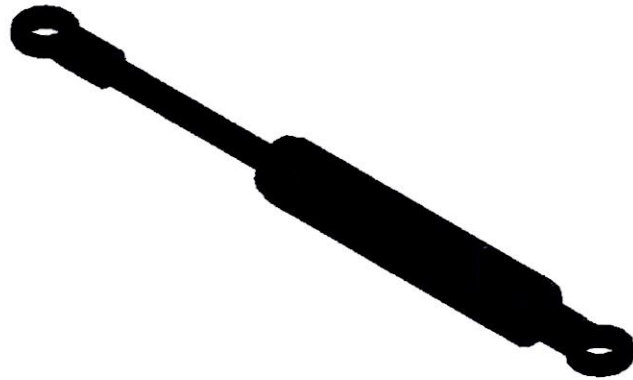
D2807-3 LUG NOTES:

- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.016 LBS

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. E
MFG. APPR.		D2807	SHEET 2 OF 3
APPROVED	MF	TITLE	SCALE
DE APPR.		GAS SPRING	4:1
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MF
#157058

RELEASED



D2807-5 GAS SPRING



D2807-5 GAS SPRING NOTES:

- 1) POSSIBLE SUPPLIER: LIFT SUPPORT TECHNOLOGIES, SASKATOON, CANADA
(P/N 6/15-164/50-115N)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) SPECIFICATION: SS GAS SPRING WITH END FITTINGS.
ACCEPTABLE LOAD RANGE 25 LB (115 N) MIN TO 45 LB (200 N) MAX

RELEASED
08-01-12

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KE	DRAWING NO.	REV. E
MFG. APPR.	KE	D2807	SHEET 3 OF 3
APPROVED	KE	TITLE	SCALE
DE APPR.	KE	GAS SPRING	4:1
DATE	07.12.28	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

LS Technologies Inc
314 Jessop Ave
Saskatoon, SK S7N 1Y6

Ph: 306-683-5000 Fax: 306-683-6403

Packing Slip

P.O. No.	Date	Invoice #
35290	2/15/2017	16098

Bill to:
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship to:
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship	Via	FOB
2/15/2017	Fed-Ex	

Qty	Description
24	D2807-041 B157058 Stainless Gas Spring (6/15-164/50-115N)
1	Shipping Via FED EX Tracking # 778437901153

SP17-02-17

Order checked by :

[Signature]



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO35290

Purchase Order Date 2/13/2017

PO Print Date 2/13/2017

Page Number 1 of 1

Order From :

VC-LST0001

Ship To : DART AEROSPACE LTD

LS TECHNOLOGIES INC.
314 JESSOP AVE
SASKATOON, SK S7N 1Y6
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

FEB 13 2017

Contact Name
Vendor Phone 306 683 5000

Ship To Contact
Ship To Phone
Ship Via: FedEx Overnight collect
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB EXW - (Ex Works)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	6/15-164/50-115N AS PER DWG D2807-041 REV. E B157058	Gas Spring	2/22/2017 Yes 2/22/2017		24.00 Each	\$63.90	\$1,533.60

2017-02-17

Line Total: \$1,533.60

2	71401-45 Procurement Quality Clauses A004 faa-pma/tso A005 right of entry A016 personnel qualification A025 certification of conformance A040 notification of quality escape A043 retention of quality document	PROCUREMENT QUALITY CLAUSES	2/22/2017 No 2/22/2017		1.00	\$0.00	\$0.00
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Line Total: \$0.00

PO Total: \$1,533.60

PO Instructions: Fedex Acc#151793240

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 1

Change Date: 2/13/2017



LS Technologies Inc

314 Jessop Ave

Saskatoon, SK, S7N 1Y6

Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Conformance

Feb 15, 2017

This is to certify that the parts listed below meets specifications as required by your order.

24 Units : D2807-041 B157058 Stainless Gas Spring (6/15-164/50-115N)

Country of Manufacture : Canada

Date of Manufacture : Feb 2017

This product is ROHS compliant.

Purchase Order # 35290

Inv# 16098

L S Technologies Inc Canada

A blue ink signature of Nolan Fehr, written over a horizontal line.

**Nolan Fehr
President**